

Dereu 55290

Work Order ID 53225

October 27, 2009 1:05:07 PM

Page 1

Item ID: D3943-051

Accept

Revision ID: B

Item Name: Handle Assembly

Setup Start

Stop

Start Date: 10/27/2009 Start Qty: 9.00

Required Date: 11/2/2009 Req'd Qty: 9.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: ymf Date: 09-10-27 Tooling:

Date:

Run Start

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3943

B

100

Weld per dwg A/R Steel rod Batch: M111385 0.00

Large Fab

Memo

0.00

Large Fab

110

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Plc 09 11 10

9

09.11.11

D 09.11.11 9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 53225

October 27, 2009 1:05:07 PM

Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

0.00

Memo

0.00

1- MASK THREADS PRIOR TO PAINTING AS PER DWG

~~2- SPRAY PAINT YELLOW AS PER DWG~~

A/R BATCH: M113544

Start: 2:00pm

Temp: 320°F

Stop: 2:30pm

140



QC

Quality Control

QC14- Inspect Spray Paint

0.00

QC3

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: W/O

0.00

Memo

0.00

52944

EL 10-1-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 53225

October 27, 2009 1:05:07 PM



Page 3

Item ID: D3943-051

Accept



Setup Start



Revision ID: B

Item Name: Handle Assembly

Stop



Start Date: 10/27/2009 Start Qty: 9.00



Cust Item ID:

Required Date: 11/2/2009 Req'd Qty: 9.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/01/13

MF 10-1-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

October 27, 2009 1:05:06 PM

Page 1

Work Order ID: 53225

Parent Item: D3943-051RevA

Parent Item Name: Handle Assembly

Comments:

Start Date: 10/27/2009

Required Date: 11/2/2009

Start Qty: 9.00

Required Qty: 9.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D3943-5RevA

Manufactured

No

100

Each

13.0000

9.0000



Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

52095

5

52979

8

D3943-7RevA

Manufactured

No

100

Each

48.0000

18.0000



Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

48337

2

52096

8

52192

4

52278

4

52980

30

Cpl 09/11/05

*(4) ✓
(5) ✓*

Cpl 09.11.05

*(3) ✓
(4) ✓
(6) ✓*

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NOTE: Date & initial all entries

| ITEM No. | QTY -041 | QTY -051 | QTY -053 | PART NUMBER | DESCRIPTION | PREFERED SUPPLIER |
|----------|----------|----------|----------|-------------|---|---------------------------------------|
| 1 | X | | | D3943-041 | GROUND HANDLING CRANK ASSEMBLY | |
| 5 | 1 | X | | D3943-051 | HANDLE ASSEMBLY | |
| 6 | 1 | | X | D3943-053 | CHAIN ASSEMBLY | |
| 11 | | 1 | | D3943-1 | HANDLE | M/F HANDLE FROM DIS-ASSEMBLED ITEM 39 |
| 12 | 1 | | | D3943-3 | HANDLE EXTENSION | |
| 13 | | 1 | | D3943-5 | PLATE | |
| 14 | | 2 | | D3943-7 | STUD | |
| 15 | | | 1 | D3943-9 | CHAIN | USE CHAIN SUPPLIED WITH ITEM 39 |
| 21 | 1 | | | D2690-4 | LANYARD | |
| 22 | 1 | | | D3585-1 | SET SCREW | |
| 23 | 1 | | | D3949-041 | REMOVE BEFORE FLIGHT FLAG | |
| 24 | | | 1 | D3954-5 | CHAIN LUG | |
| 25 | 1 | | | D3954-7 | RATCHET LUG | |
| 26 | | | 1 | D3954-9 | GWT CHAIN PIN | |
| 31 | 1 | | | AN5-11A | BOLT | |
| 32 | 1 | | | AN960-516 | WASHER | |
| 33 | 1 | | | MS21042L5 | NUT | |
| 39 | 1 | | | 8143919 | LEVER CHAIN HOIST (POWER FIST) | PRINCESS AUTO / 4000 lbs CAPACITY |
| 41 | 1 | | | S-1475 | SPRING | REID SUPPLY |
| 42 | 1 | | | 3408A59 | BALL PLUNGER | McMASTER CARR |
| 43 | 3 | | | HX-15 | SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG | HASKINS |

RELEASED
2009-10-19

| | | | |
|------------|---|--|--------------|
| B | SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT. | AJS | 09.10.15 |
| A | NEW ISSUE | AJS | 09.05.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DSTOW / AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | DRAWING NO. | REV. B |
| CHECKED | | D3943 | SHEET 1 OF 5 |
| MFG. APPR. | | TITLE | SCALE |
| DE APPR. | N/A | GROSS WEIGHT TOW CRANK ASSY | NTS |
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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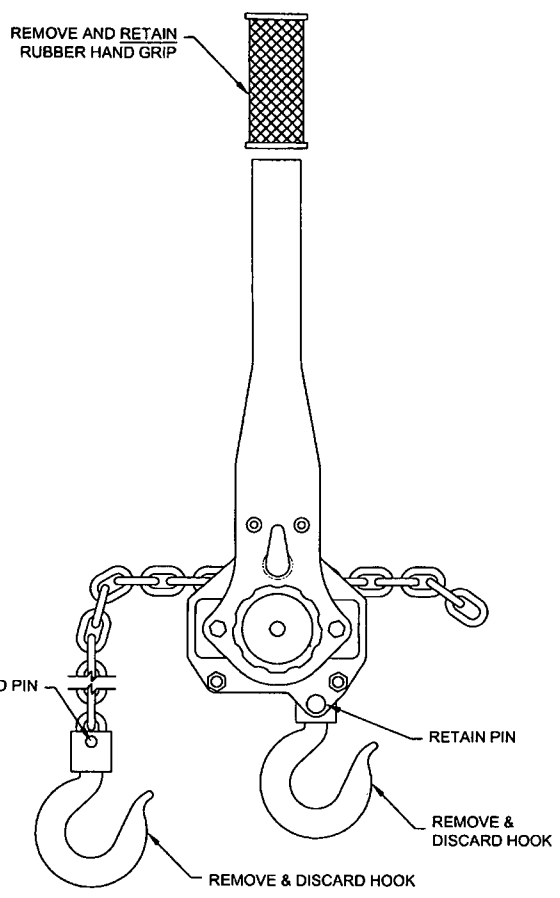
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B

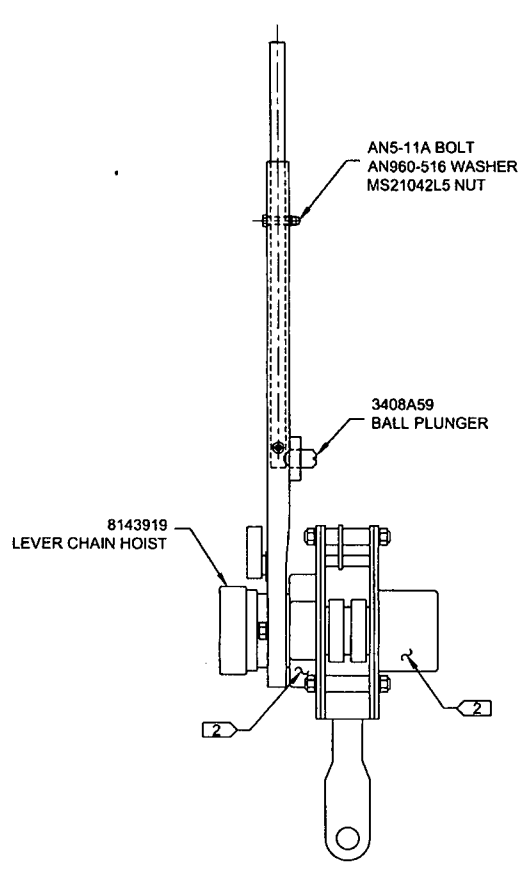
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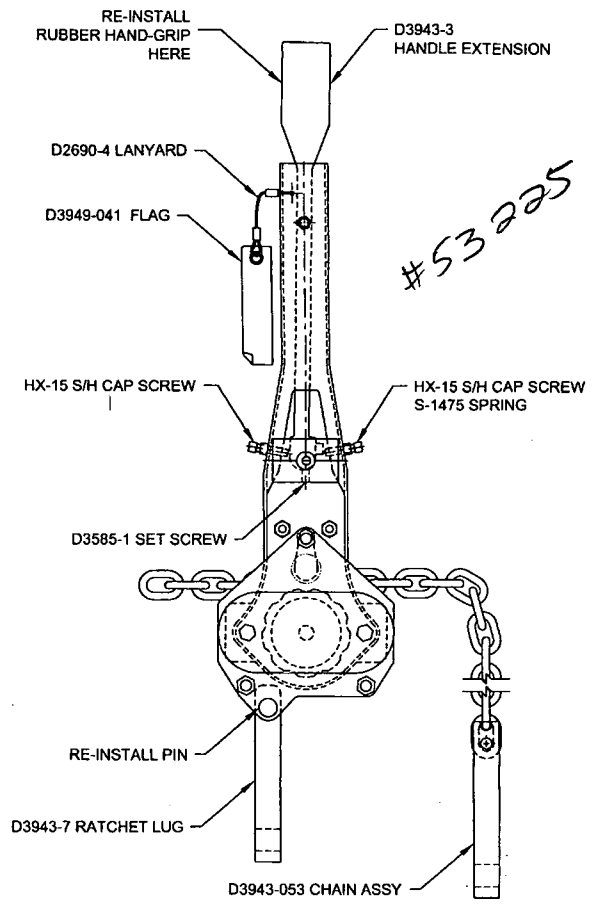
B



8143919 LEVER CHAIN HOIST
(SHOWN PRIOR TO MODIFICATION)
(CHAIN SHOWN SHORTENED FOR CLARITY)



(CHAIN NOT SHOWN FOR CLARITY)



(CHAIN SHOWN SHORTENED FOR CLARITY)

#53225

D3943-041 GROUND HANDLING CRANK ASSEMBLY

- NOTES -041:**
- 1) MATERIAL: N/A
 - 2) FINISH: DISASSEMBLE LEVER CHAIN HOIST (ITEM 39) AND SPRAY PAINT YELLOW WITH BERTRAND CG10318 PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3943-041" USING FINE POINT PERMANENT INK MARKER

RELEASED
2009-10-19

| | | | |
|------------|-------------|---|--------------|
| DESIGN | DSTOW / AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | DRAWING NO. | REV. B |
| CHECKED | | D3943 | SHEET 2 OF 5 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | GROSS WEIGHT TOW CRANK ASSY | NTS |
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| DATE | 09.10.15 | | |

8 7 6 5 4 3 2 1

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

D3943-1 HANDLE

2 PL

9.75

2.00

0.41

Ø0.31
THRU

Ø0.12
THRU

D3943-7 STUD
2 PL

THREAD 1/2-20 UNC-2B
2 PL

THREAD 1/2-20 UNC-2B
THRU

VIEW A-A
(SCALE 2X) A5-3
B5-3

2 PL

9.37

A B1-3

A B1-3

D3943-5 PLATE



D3943-051 HANDLE ASSEMBLY

NOTES -051:

- 1) MATERIAL : N/A
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND 6GT031B PER DART QSI 005 4.2
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO POWDER COATING

Powercoat Hybrid Yellow HS112 Y12
PAK 100-C01 710.01.07

MP 02/1/07

| | | | |
|---|---|--|--------------|
| DESIGN | DSTOW / AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. |  | D3943 | SHEET 3 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | AJA | GROSS WEIGHT TOW CRANK ASSY NTS | |
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

D3943-9 CHAIN

D3954-5 CHAIN LUG

C

C


B




B

D3943-053 CHAIN ASSEMBLY

RELEASED
2009-10-19
MP

NOTES -053:

- 1) MATERIAL: N/A
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2 
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER QSI 004
- 9) MASK CHAIN FROM THIS POINT ON PRIOR TO POWDER COATING

| | | | |
|--|---|--|--------------|
| DESIGN | DSTOW / AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. |  | D3943 | SHEET 4 OF 5 |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

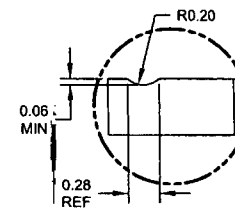
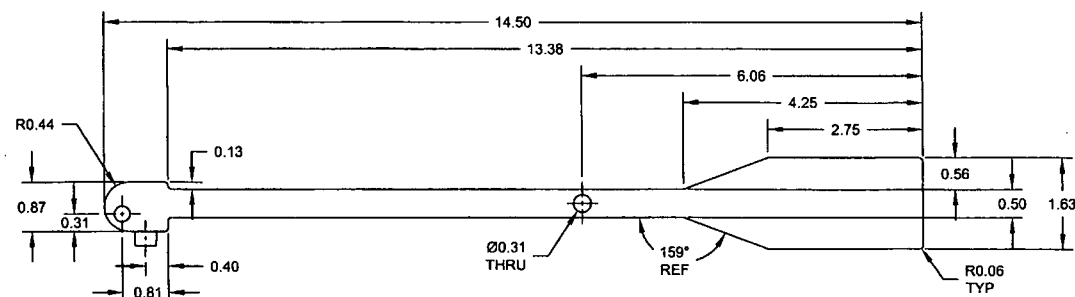
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NOTE: Date & initial all entries

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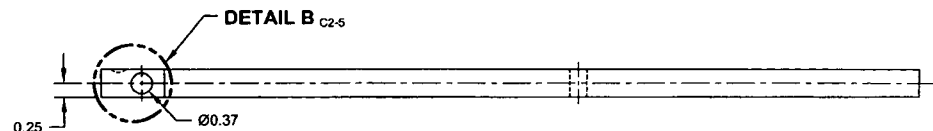
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DETAIL B-B
(DIMPLE DETAIL)
(SCALE 2X)

#53225

C



D3943-3 HANDLE EXTENSION

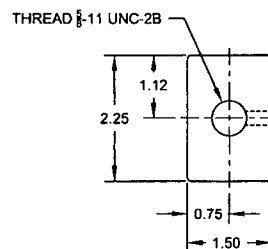
B

NOTES -11/-13:

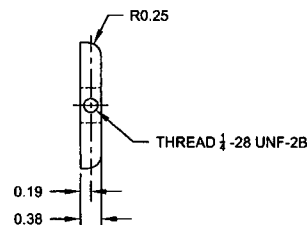
1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR : MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

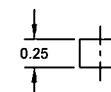
-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R



D3943-5 PLATE





Ø0.37 PILOT HOLE PER SHOP REQUIREMENT



D3943-7 STUD
(SCALE 2X)

RELEASED
2009-10-19

- 2) FINISH -3: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

| | | | |
|--|---|--|--------------|
| DESIGN | DSTOW / AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. |  | D3943 | SHEET 5 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | AJA | GROSS WEIGHT TOW CRANK ASSY | NTS |
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8 7 6 5 4 3 2 1

A

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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